

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014026**Date Inspected:** 18-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Jhou Cheng/Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

BAY#8

FCAW welding of weld joint BK004A7-056-067, 068 located on BK004A-056. Welder is identified as 040671 (2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-056-217, 230 located on BK004A-056. Welder is identified as 040671 (2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A7-056-007, 008 located on BK004A-056. Welder is identified as 040671 (2F). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint BK004A1-056-043 located on BK004A-056. Welder is identified as 054459 and 054460 (2G). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4c-F.

WELDING INSPECTION REPORT

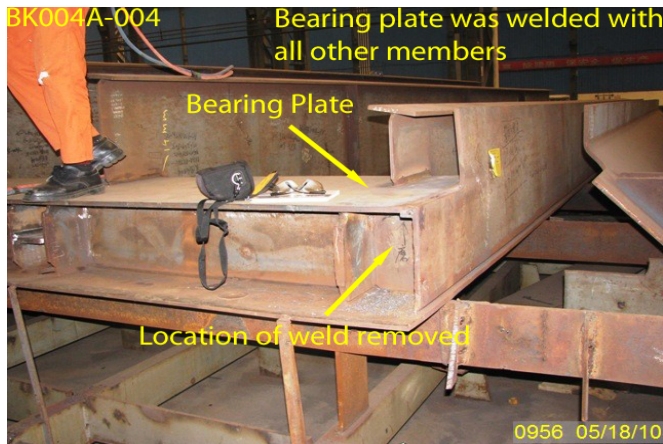
(Continued Page 2 of 2)

FCAW welding of weld joint BK004A5-056-090 located on BK004A-056. Welder is identified as 054459 (2G). ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-B-U2-F.

BAY#19

During random in process inspection of bike path, BK004A-004, this QA inspector observed following issue: ZPMC personnel performed welding on end diaphragm plate (BKX11B) to bearing plate (BKPL7A and BKPL7B). According to approved drawing, this joint is tight fit, no welding (Please see incident report generated by QA inspector B247 on 05.17.2010). ZPMC personnel remove the welding without engineer's approval. For further information, please see attached pictures.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
